

M36 Stud Bolt Torque Chart

M36 · 6 property classes · K 0.12 / 0.15 / 0.20 · N·m · target preload kN · coarse + fine thread

M36

As 817 mm² · N·m

Torque by Property Class and Nut Factor K

Class	Rp0.2 (MPa)	Target preload (kN)	K 0.12 N·m	K 0.15 N·m	K 0.20 N·m
4.8	340	194.4	840	1050	1400
8.8	640	366	1581	1976	2635
10.9	940	537.6	2322	2903	3871
12.9	1100	629.1	2718	3397	4529
A2-70	450	257.4	1112	1390	1853
A4-80	600	343.1	1482	1853	2471

Each K column shows the tightening torque at that nut factor (N·m). K combines thread and bearing-surface friction: 0.12 ≈ well lubricated (MoS₂ / assembly paste), 0.15 ≈ normal assembly oil (typical default), 0.20 ≈ unlubricated or plated surfaces. Select by your actual lubrication condition; verify on site for critical joints.

Fine-Thread Torque Matrix

Fine-thread series (M36 × 3 mm) target preload and tightening torque, same basis as the coarse chart; the fine-thread stress area As follows ISO 898-1:2013 Table 6 (this page takes M36 As = 865 mm²).

Class	Rp0.2 (MPa)	Target preload (kN)	K 0.12 N·m	K 0.15 N·m	K 0.20 N·m
4.8	340	205.9	889	1112	1482
8.8	640	387.5	1674	2093	2790
10.9	940	569.2	2459	3074	4098
12.9	1100	666.1	2877	3597	4796
A2-70	450	272.5	1177	1471	1962
A4-80	600	363.3	1569	1962	2616

Basis of Calculation & Sources

Torque follows the K-factor (nut factor) method $T = K \cdot D \cdot F$: D is the nominal diameter and F the target preload = 70% of $Rp0.2 \times$ thread stress area (size As = {as} mm²). Yield strengths are published values from ISO 898-1 (carbon/alloy steel) and ISO 3506-1 (stainless A2/A4). The three K columns follow the standard stud-bolt torque table format (K = 0.12 / 0.15 / 0.20), the same three-column output as the online torque calculator's stud bolt mode.

Boundary: this chart is a simplified K-factor estimate, not a full VDI 2230 analysis (which also accounts for joint resilience, embedment and assembly method). Friction and lubrication are the dominant variables — the spread between K 0.12 and K 0.20 can reach ~65% of the torque value. Always follow the design specification or the manufacturer's torque table.

References

- ISO 898-1:2013 — Mechanical properties of fasteners made of carbon and alloy steel — <https://www.iso.org/standard/60610.html>
- ISO 3506-1:2020 — Mechanical properties of corrosion-resistant stainless steel fasteners (A2/A4) — <https://www.iso.org/standard/70045.html>
- GB/T 3098.1-2010 — Mechanical properties of bolts, screws and studs (CN national standard, official full text) — https://openstd.samr.gov.cn/bzgk/gb/std?std_no=GB%2FT%203098.1-2010
- GB/T 3098.6-2014 — Mechanical properties of stainless steel bolts, screws and studs (CN, official full text) — https://openstd.samr.gov.cn/bzgk/gb/std?std_no=GB%2FT%203098.6-2014
- ISO 16047:2005 — Fasteners: torque/clamp force testing (K-factor measurement method)
- Machinery's Handbook (30th ed.) — empirical K-factor ranges
- Machine Design — anti-seize compound friction test (K≈0.10)

Disclaimer: This chart is an engineering estimation for selection and budgeting only. It does not constitute assembly instructions or acceptance criteria.

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